

Date: Wednesday, 6/6/2007 1:48:39 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 32781  
Estimate Number : 10692  
P.O. Number : *N/A*  
This Issue : 6/6/2007 S.O. No. : *N/A*  
Prsht Rev. : NC  
First Issue : *N/A* Type : MACHINED PARTS  
Previous Run : 32515  
Written By : \_\_\_\_\_  
Checked & Approved By : *[Signature]* 07.06.07  
Comment : Est A 04.07.14 New issue KJ/JLM

Drawing Name	: SPACER				
Part Number	: D32863				
Drawing Number	: D3286 REV A				
Project Number	: N/A				
Drawing Revision	: A				
Material	: N/A				
Due Date	: 6/13/2007	Qty:	30	Um:	Each

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 0.3588 f(s)/Unit Total: 10.7636 f(s)  $\rightarrow 36 \text{ pcs} \times 0.3588 = 12.9168 \text{ f(s)}$   
 304 RD Tube .500 x .049W  
 Turn (2) D3286-3 per (1) skidtube assemblyDwg D3286  
 Material: AISI 304/316 SS tubing 0.500" OD x 0.049" wall  
 (M304TR0.500W.049)  
 Identify as D3286-3  
 Batch: 1104862 DSP 07/07/10

Batch: M104862 DJP 07/07/03

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL  
Turn blanks as per Folio FA434 and Dwg D3286

DJP 07/07/03 (36)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

DSP 07/07/03 36

4.0      QC8      SECOND CHECK



Comment: SECOND CHECK

36 07.07.03

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Debur

EG 07-07-03 36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: RD Date: 07/07/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:48:39 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 32781

Part Number: D32863

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SG 07-07-03 36

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

BORC 47

P 07/1/04

(36)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(36)

Comment: FINAL INSPECTION/W/O RELEASE

10/07/04

Job Completion



U 07-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

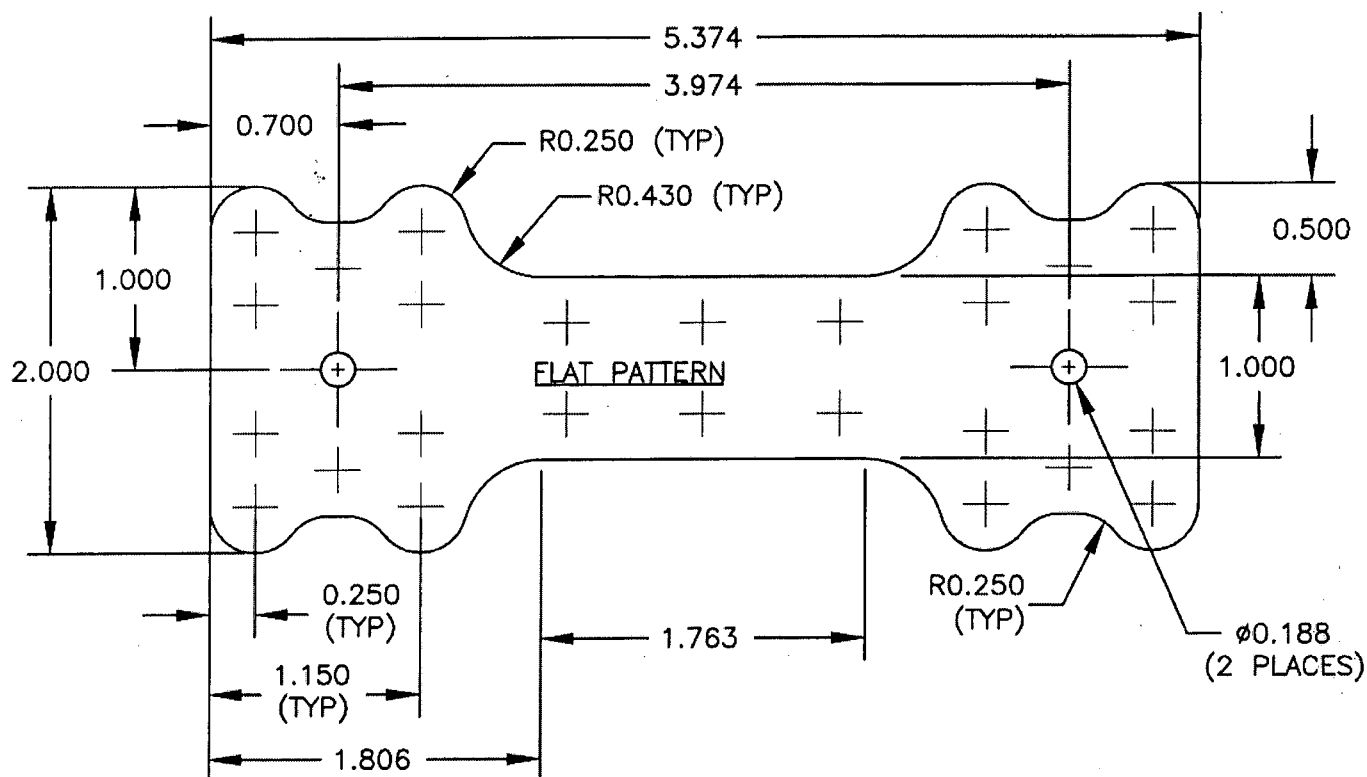
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



BENDING DETAIL

R1.51

RELEASED  
04.06.22

### D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK  
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

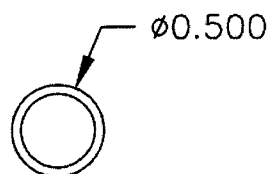
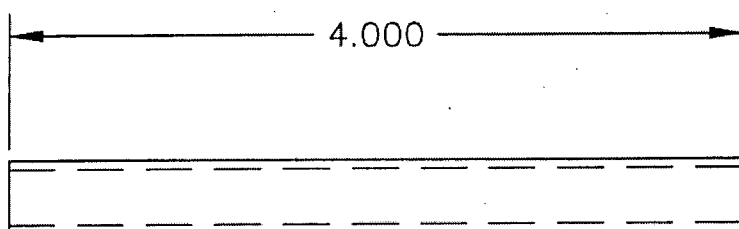
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WORK ORDER  
NO. 32781

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



**D3286-3 SPACER**

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL  
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
04.06.22 *[Signature]*

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